

Date: Wednesday, 11/22/2006 1:39:31 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 29647A	
Estimate Number : 10452	
P.O. Number : <i>NIA</i>	Part Number : D32781
This Issue : 11/22/2006 S.O. No. : <i>NIA</i>	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 29236A	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 11/29/2006
Checked & Approved By : <i>[Signature]</i>	Qty: <i>30</i> Um: Each
Comment : Est:A 04.04.19 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B1000X02000

6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.2454 f(s)/Unit Total: 12.2693 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick  
 (M6061T6B1.000x02.000)

Batch:

*719295**mk 07/01/08*

*571-10565*  
*was sent and*  
*scrapped.*  
*(runny material.)*

2.0

SHEAR

*SAW*

SHEAR



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

*mk 07/01/08**571-06112105*

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-1

*JL/J.F. 07/01/09*

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JL/J.F. 07/01/09*

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*MS**07/01/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-1 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: [Signature] Date: 07/01/26  
 QA: N/C Closed: [Signature] Date: 07.01.26

NCR: <u>29647A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/05	2	Material was cut too long because it was identified wrong. S WAS missing on mat'l size	<u>[Signature]</u> 05/10/02 07/01/08	Material is no good for these supports. <del>Scrap</del> material. replace with correct mat'l. <del>Scrap</del> <del>not material use for testing</del>	J.G 06/12/05	<u>[Signature]</u> 06/12/05	<u>[Signature]</u> 05/10/02 07/01/08	<u>[Signature]</u> 06/12/05
07/01/12	3	- 15 parts hole $\phi$ .098 is off by .030 on dimension .250 - origin moved in machine - machine malfunction	<u>[Signature]</u> 07/01/12	- assemble parts with red X on them together Scrap: destroy.	J.L 07/01/12	<u>[Signature]</u>	<u>[Signature]</u> 05/10/02	<u>[Signature]</u> 07/01/22
07/01/12	3	- 3 parts scrapped dimension - 119 $\pm$ .005 - 119 $\pm$ .004 is under tolerance	<u>[Signature]</u> 07/01/12	- scrap + replace - destroy	J.L 07/01/12	<u>[Signature]</u> 07/01/23	<u>[Signature]</u> 05/10/02	<u>[Signature]</u> 07/01/22

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 29647A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YL

07/01/24 x15

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR/YL

07/01/24 (15)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/01/24

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: A418

EP 04/04/25 (15)

B

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/01/26

Job Completion



U 07.01.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	29647A
<b>Description:</b> Support		<b>Part Number:</b>	D3278-1
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.099	✓			
0.359	+/-0.005	.359	✓			
0.615	+/-0.010	.				
0.250	+/-0.010	.251	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	r.125	✓			
0.119	+0.005/-0.004	.124				
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.985	✓			
R0.130	+/-0.010	r.130	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.375	+/-0.010	r.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	r.400	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	r.125	✓			
0.125	+/-0.010	.130	✓			

<b>Measured by:</b>	J.L	<b>Audited by:</b>	JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/01/08	<b>Date:</b>	07/01/08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue      P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

-124  
-115

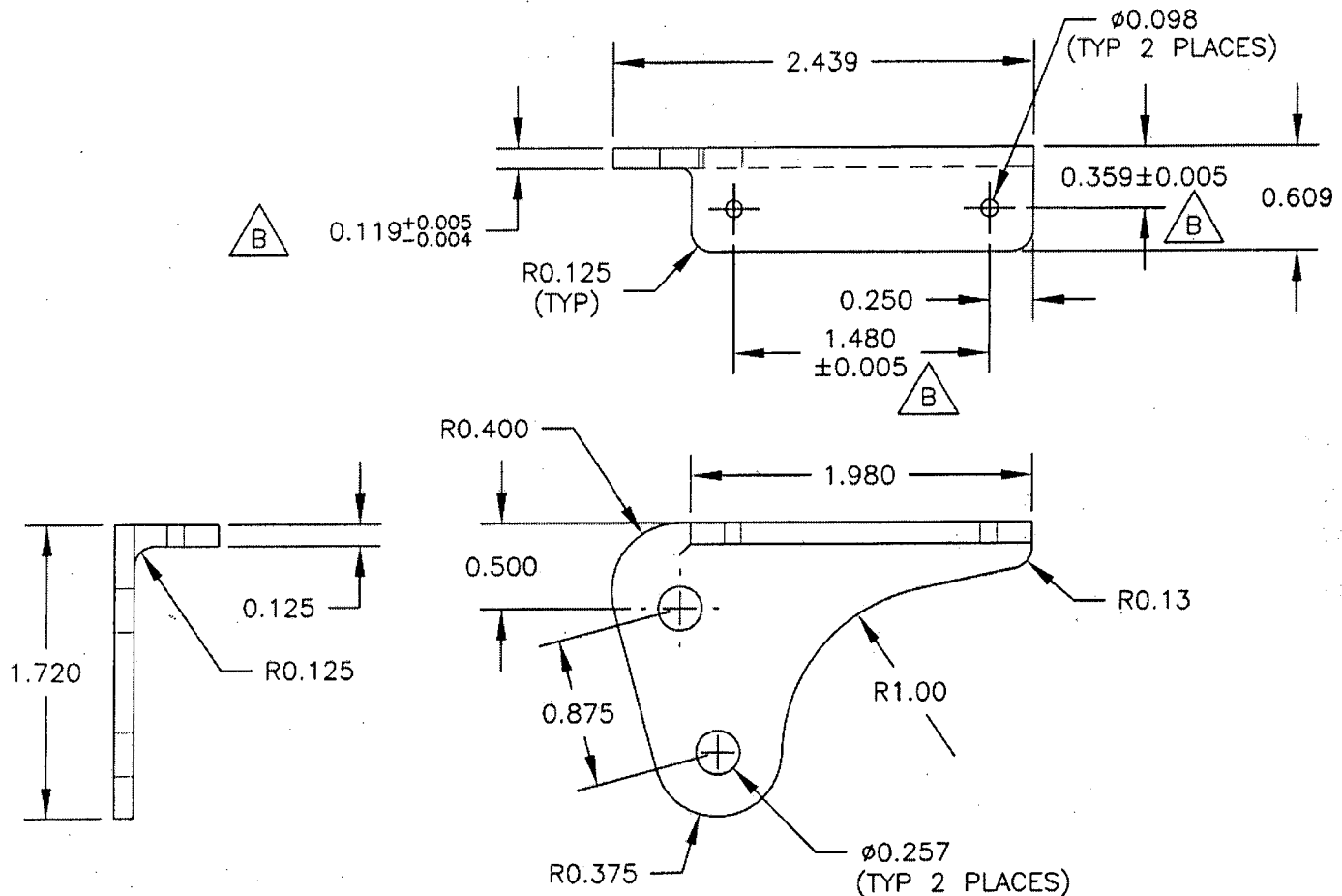
**DART**

-364  
-354

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)



- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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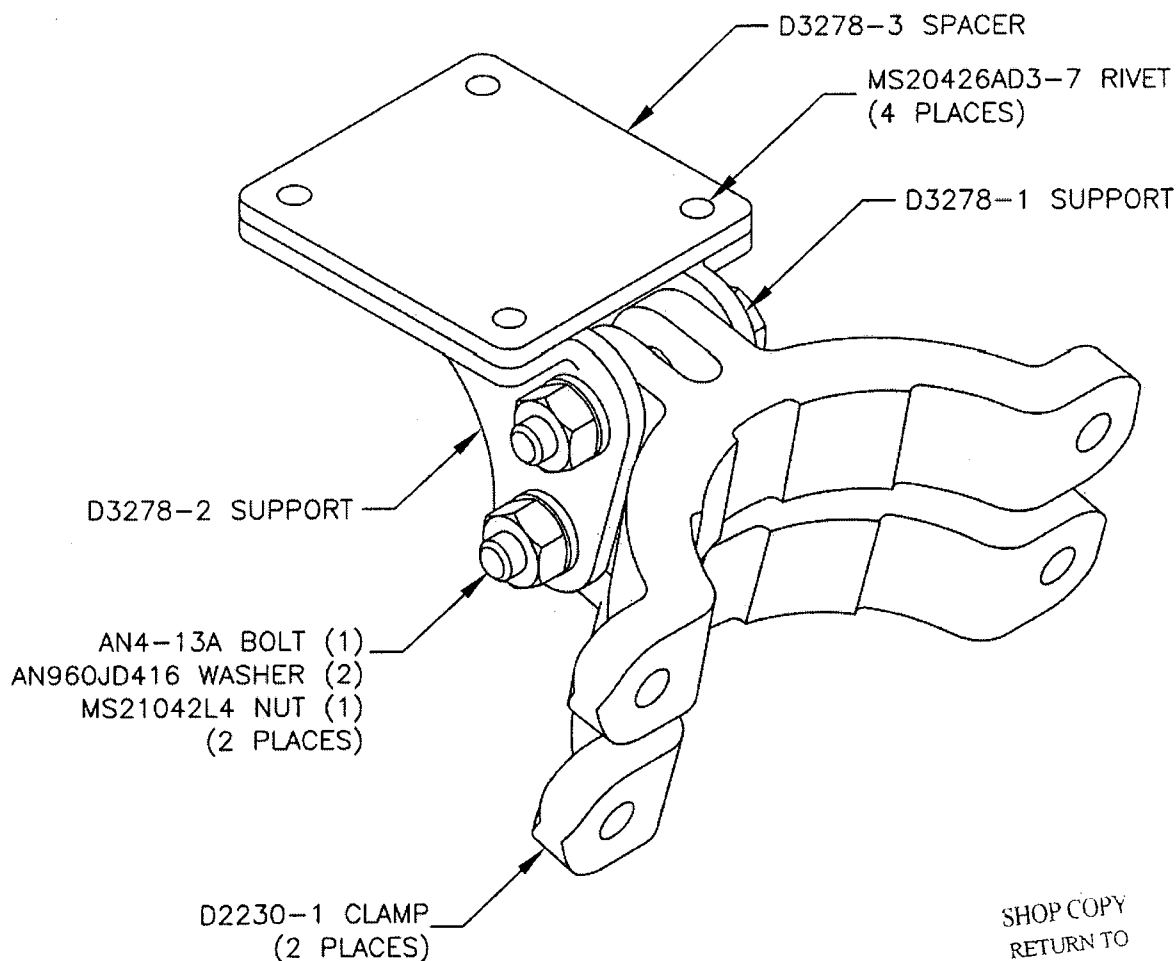
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CHECKED 		APPROVED 		DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31			TITLE SUPPORT ASSEMBLY SCALE NTS		
A	04.03.03		NEW ISSUE		
B	05.03.31		CHANGE DIM/TOL TO ENSURE FIT		

RELEASED  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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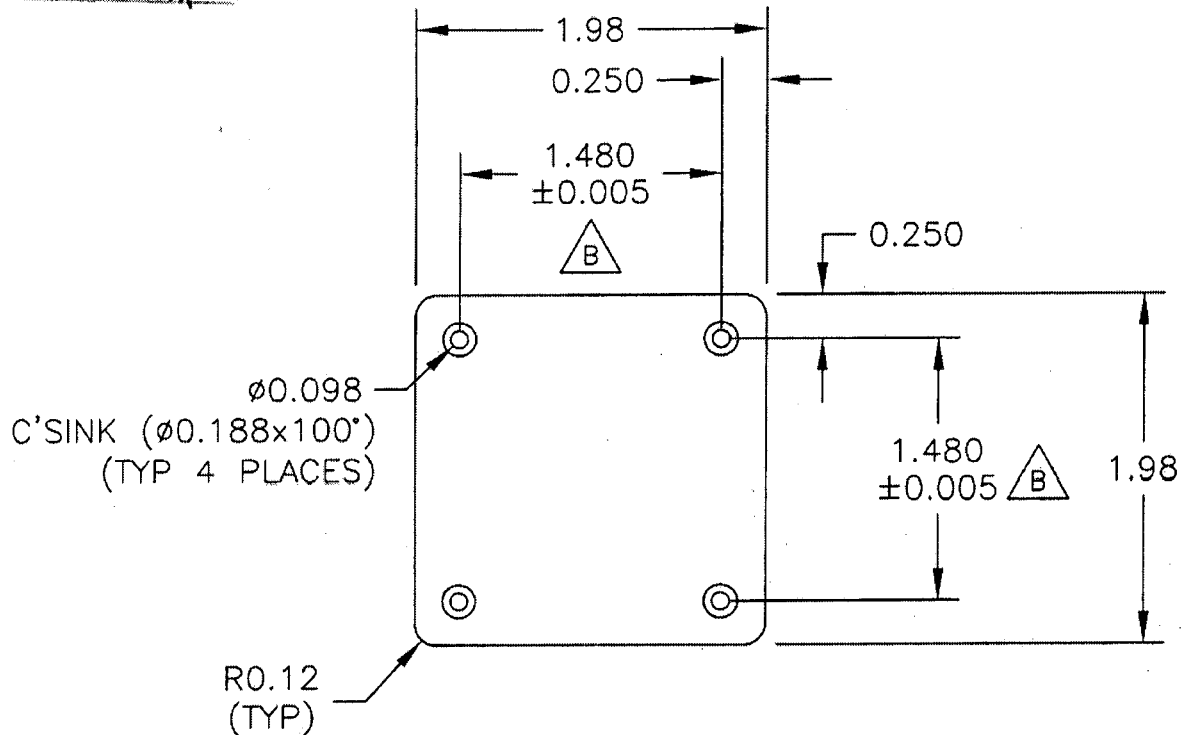
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 [Signature]

**D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B. OR M-DELIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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